

Date: Friday, 27/02/2009 10:35:52 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE, INBOARD, RS, 206
Job Number : 46100	
Estimate Number : 10821	
P.O. Number :	Part Number : D26662
This Issue : 27/02/2009 S.O. No. :	Drawing Number : D2666 REV.D
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : D
Previous Run : 44285	Material :
Written By :	Due Date : 11/03/2009 Qty: 8 Um: Each
Checked & Approved By : <u>JLD 09.02.27</u>	
Comment : Est: C - 00.11.01 Removed P/O for Powder Coat - in house processEC Est Rev:D As per Rev D 07-03-19 JLM	

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

D6101001

Saddle Billet



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

7075-T7351 2X6X6.25

Issue material from stock:

Cut Size 2.0 x 6.25 X 6.0

Grain Along Long 6.0 Length

Batch No: B34872 J.F. 09/03/09 (8)

2.0

HAAS1

HAAS CNC VERTICAL MACHINING #1

**Comment:** HAAS CNC VERTICAL MACHINING #1

Program batch number.

1-Inspect part number and batch number are programmed correctly.

4-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet

5-Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet

6-Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet

7- Deburr

J.F. 09/03/09 (8)

3.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE

**Comment:** CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

J.F. 09/03/09 (8)

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 09/03/09 (8)

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: SADDLE, INBOARD, RS, 206

Job Number: 46100

Part Number: D26662

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

BR 09/05/09

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

BR 09-03-11

(8)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

W 110939

START TIME:

9:25

OVEN TEMPERATURE:

320°

FINISH TIME:

9:55

BR 09-03-12

(8)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

911

09-03-12

(8)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

424

9/3/13

(8)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

AD 09/03/16

(8)

Job Completion



W 09.03.16

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 46100
Description: 206 Saddle, Inboard, Right side	Part Number: D2666-2
Inspection Dwg: D2666 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.122"	.121"	.121"	.120"		
B	0.100	0.140		.102"	.111"	.110"	.109"		
C	2.470	2.510		2.494"	2.494"	2.494"	2.494"		
D	0.100	0.180		.140"	.140"	.140"	.140"		
E	0.210	0.230		.211"	.219"	.217"	.216"		
F	1.313	1.343		1.317"	1.322"	1.322"	1.322"		
G	0.240	0.260		.245"	.251"	.251"	.251"		
H	0.615	0.685		.658"	.658"	.658"	.658"		
I	1.125	1.145		1.131"	1.133"	1.132"	1.131"		
J	0.990	1.010		1.004"	1.004"	1.004"	1.004"		
K	0.235	0.240		.240"	.237"	.237"	.237"		
L	0.510	0.515		.511"	.511"	.511"	.511"		
M	0.100	0.120		.115"	.115"	.115"	.115"		
N	1.565	1.585		1.571"	1.573"	1.572"	1.571"		
O	5.990	6.010		6.000"	6.000"	6.000"	6.000"		
P	1.245	1.255		1.250"	1.250"	1.250"	1.250"		
Q	2.495	2.505		2.500"	2.500"	2.500"	2.500"		
R	0.490	0.510		.502"	.503"	.505"	.506"		
S	0.313	0.318		Ø.315"	Ø.315"	Ø.315"	Ø.315"		
T	2.495	2.505		2.499"	2.499"	2.499"	2.499"		
U	1.357	1.367		1.363"	1.363"	1.363"	1.363"		
V	0.315	0.322		Ø.317"	Ø.317"	Ø.317"	Ø.317"		
W	0.540	0.560		.550"	.550"	.550"	.550"		
X	1.674	1.684		1.680"	1.680"	1.680"	1.680"		
Y	0.257	0.262		Ø.259"	Ø.259"	Ø.259"	Ø.259"		
Z	0.178	0.198		R.188"	R.188"	R.188"	R.188"		
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: J.F.
Date: 09/03/08

Audited by: [Signature]
Date: 09/03/09

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

W/O:		WORK ORDER CHANGES					
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D	0.100	0.180		.140"	.140"	.140"	.140"		
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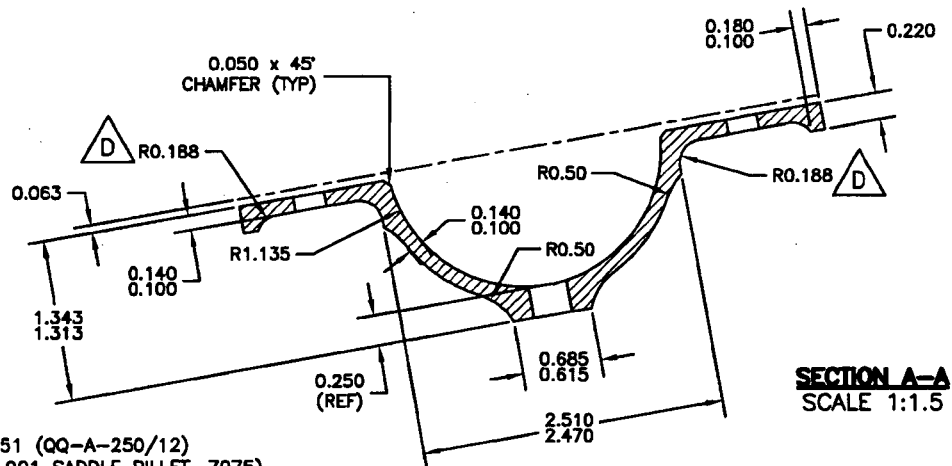
NOTE: Date & initial all entries

DART

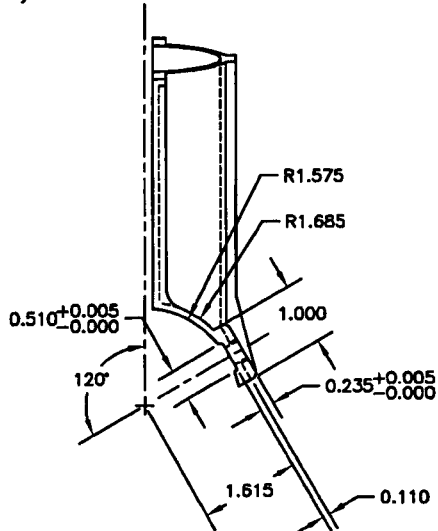
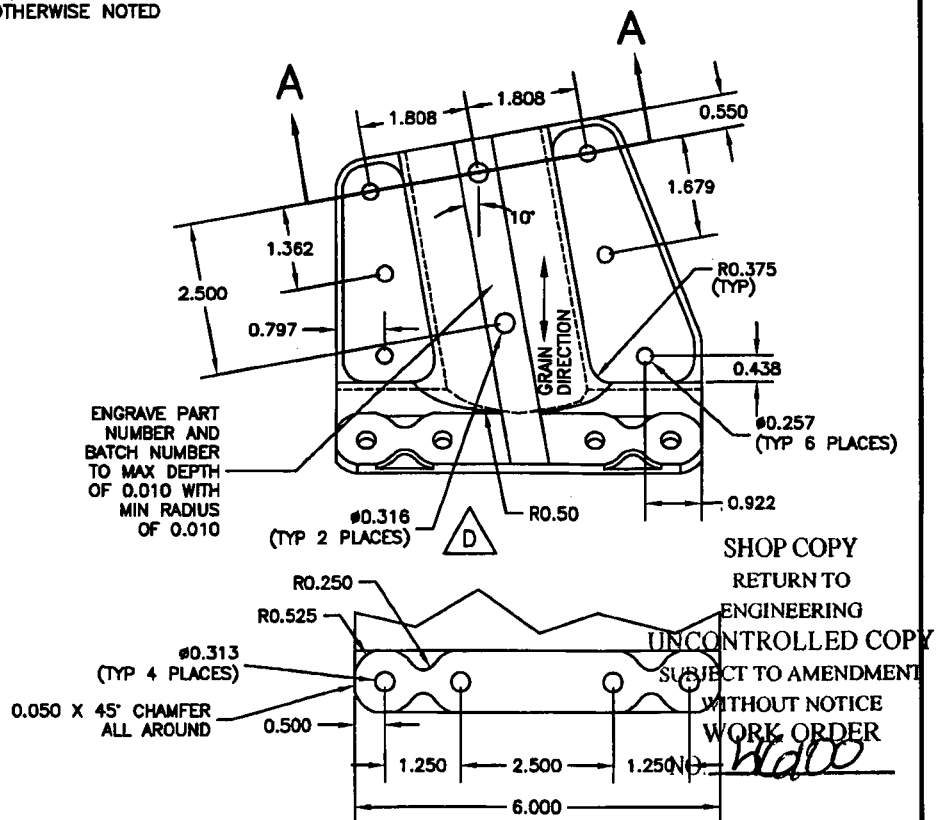
RELEASED

07.02.12

DESIGN #	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED #	DRAWING NO. D2666	REV. D SHEET 1 OF 1
DATE 06.11.08	TITLE SADDLE FWD INSIDE HIGH		SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.26	INCORPORATE DEO 9122, 9102, 9095	
D	06.11.08	R0.188 WAS R0.30; $\phi 0.316$ WAS $\phi 0.313$	

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2666-1 SHOWN (D2666-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES

**D2666-1 SADDLE FWD INSIDE HIGH**

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